

Work Order ID 80168-1

February-13-12 10:37:26 AM

80168

Page 1

Item ID: D3295-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Floor Window

Stop *NS2*

Start Date: 13/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.S

Date: 12/02/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3295

Rev D

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3295 Dwg Rev. 8 Prog Rev. 8 2-
Remove plastic and wrap in saran wrap 2-Deburr if necessary

1312-3-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1312-3-24

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/12/13/26

4

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80168

February-13-12 10:37:26 AM

80168

Page 2

Item ID: D3295-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Window
 Start Date: 13/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 27/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3295. Put window in plastic wrap.								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: _____								
Packaging	Memo	0.00							
Packaging									

7/2 →

W/O: 80168-1

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: _____ Fault Category: Small Fab / Work NCR: Yes No DQA: AP Date: 12/05/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/5/14

NCR: <u>12-1404</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>43.45</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>12/05/14</u>	<u>130</u>	<u>Scratches found in window Damin Assembly P.L. Process 1</u>	<u>S</u> <u>12/05/14</u> <u>AST/142</u>	<u>Scrap + Destroy at + 1</u> <u>unable to remove marks</u>	<u>12-05-02</u> <u>FF</u>	<u>S</u> <u>12/05/14</u>	<u>S</u> <u>12/05/14</u> <u>AST/142</u>	<u>S</u> <u>12/05/14</u>

NOTE: Date & initial all entries

Work Order ID 80168

February-13-12 10:37:26 AM

80168

Page 3

Item ID: D3295-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Window
Start Date: 13/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 27/02/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

H 1205-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

February-13-12 10:37:32 AM

Page 1

Work Order ID: 80168

80168

Parent Item: D3295-041

D3295-041

Parent Item Name: Floor Window

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1		Manufactured	No			100	Each	0.0000	0	0			
D2728-1									**				
Dart Logo label													
MLEXS.125-9034-01		Purchased	No			140	sf	263.4000	1.24	5.221053			
MI FXS 125-9034-01									**				
1/8" 9034 Lexan Sheet													

Location

MAT019

Loc Qty

263.4

Loc Code

115861

37

117273

130.4

119591

96

115861

B2-3-24

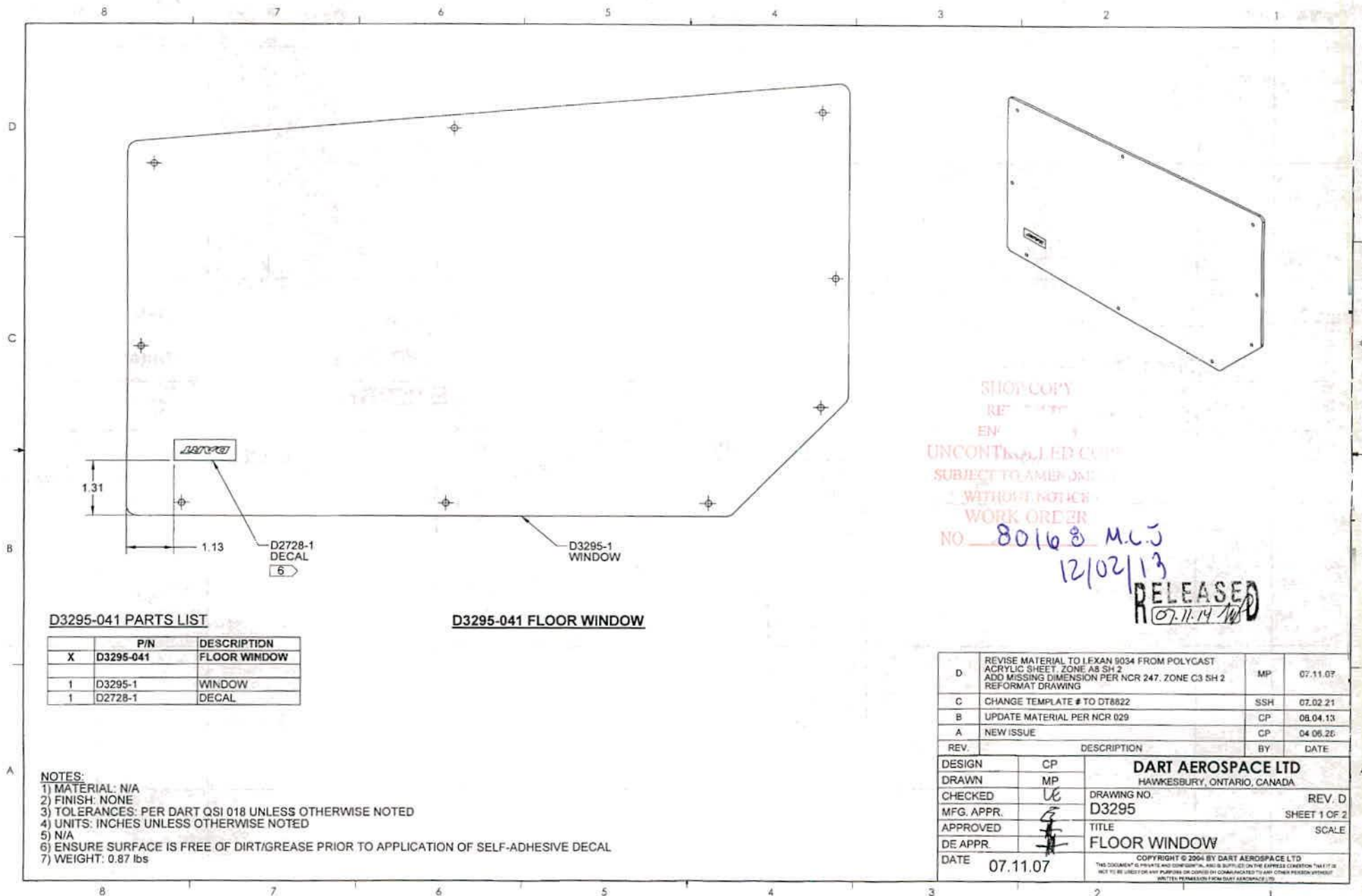
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3295-041 PARTS LIST

	P/N	DESCRIPTION
X	D3295-041	FLOOR WINDOW
1	D3295-1	WINDOW
1	D2728-1	DECAL

D3295-041 FLOOR WINDOW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) N/A
- 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
- 7) WEIGHT: 0.87 lbs

SHOOT COPY
REF: 1000
EN: 1
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80168 M.C.J.
12/02/13

RELEASED
07.11.14

D	REVISE MATERIAL TO LEXAN 8034 FROM POLYCAST ACRYLIC SHEET, ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247, ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	08.04.13
A	NEW ISSUE	CP	04.06.26
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	U	DRAWING NO.	REV. D
MFG. APPR.		D3295	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW	
DATE	07.11.07	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED OR ANY PART THEREOF OR COPIES THEREOF TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

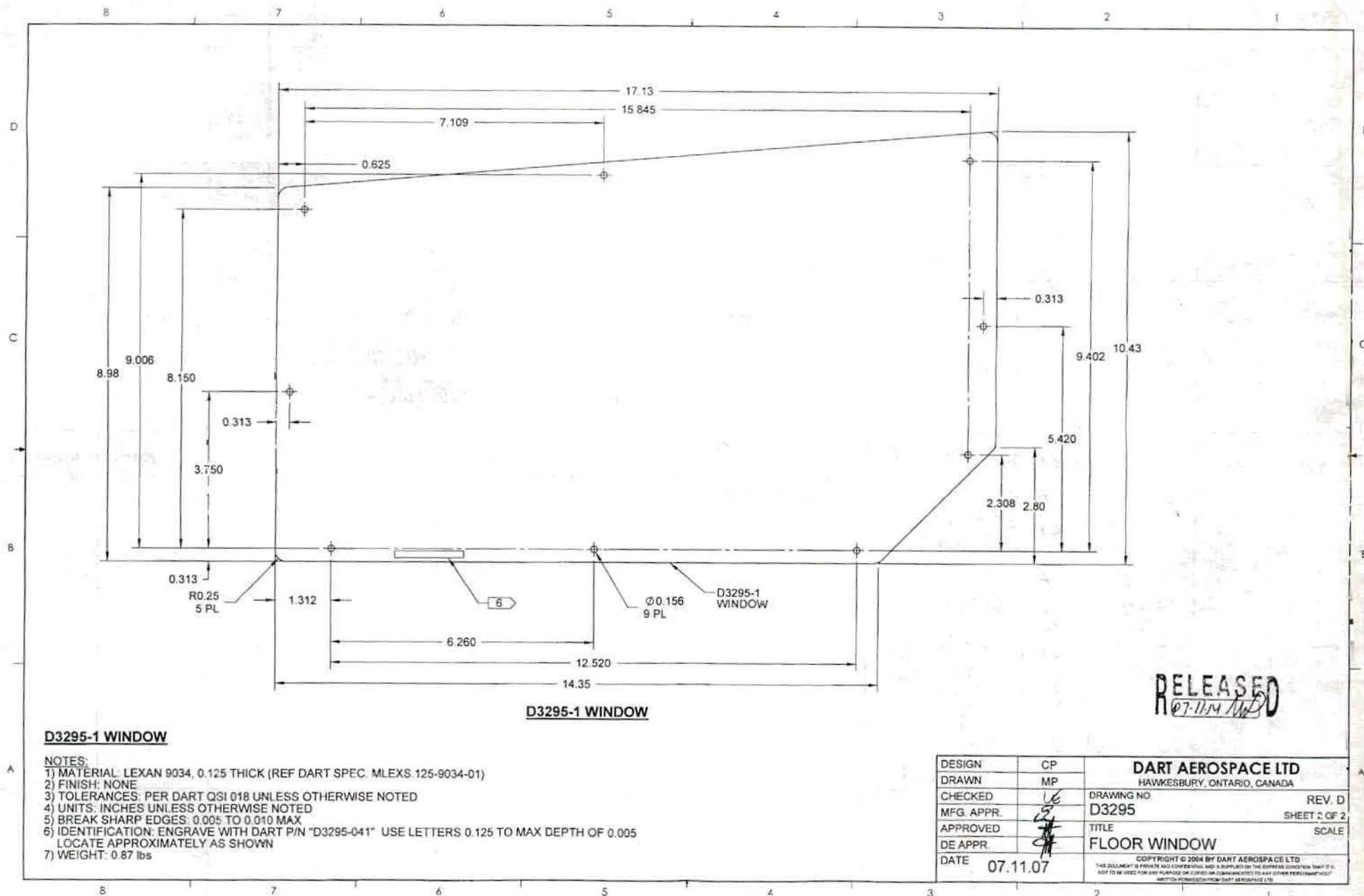
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80168



D3295-1 WINDOW

D3295-1 WINDOW

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK (REF DART SPEC. MLEXS 125-9034-01)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041" USE LETTERS 0.125 TO MAX DEPTH OF 0.005 LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

RELEASED
07-11-07

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	LE	DRAWING NO.	REV. D
MFG. APPR.	LE	D3295	SHEET 2 OF 2
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	FLOOR WINDOW	
DATE	07.11.07	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 80168
Description: FLOOR WINDOW		Part Number: D3295-041
Inspection Dwg: D3295-1 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
156	+0.05 -0.01	159	2		V/B.2	
1312	±	1317	✓		V	
6.260	±	6.258	✓		T/B.1	
12.250	±	12.250	✓		T	
2.308	±	2.305	✓		V	
5.426	±	5.419	✓		T	
9.402	±	9.406	✓		T	
10.43	±	10.43	✓		T	
3.750	±	3.748	✓		V	
313	±	315	✓		V	
8.150	±	8.151	✓		T	
9.066	±	9.083	✓		T	
8.98	±	8.98	✓		T	
6.25	±	6.26	✓		V	
7.109	±	7.105	✓		T	
15.844	±	15.845	✓		T	
12.13	±	12.13	✓		T	
125	±	120	✓		V	

Measured by: B	Audited by: S	Prototype Approval:
Date: 12-3-24	Date: 12/3/26	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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